

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000347**Date Inspected:** 02-Aug-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhou Daqing			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	N/A		

Summary of Items Observed:

The Caltrans Quality Assurance (QA) Inspector, Alfredo Acuna was present for the welder and welding operator qualification tests scheduled for this project. Moody International representative, Zhou Daqing and assistants, were observed by the QA inspector performing verifications of the welding parameters, amperages, voltages, travel speeds, preheat and interpass temperatures for the welder and welding operator qualification testing for Flux cored arc welding(FCAW), shielded metal arc welding (SMAW) and submerged arc welding (SAW).

The QA Inspector performed random verifications of amperages, voltages, travel speeds, preheat and interpass temperatures after Moody International verifications. The QA inspectors recorded that the welding parameters appeared to be in compliance with contract documents.

The QA inspector had a conversation with ZPMC representative Shen Xue Jun and ABF representative Danny McDonnald. The QA inspector asked Mr. Shen for the results from the welder/welding operator tests held on 08/01/07. Mr. Shen relayed to the QA inspector that 63 welders were tested on August, 01 and 37 welders failed the test; In addition, Mr. Shen said that 23 welders were tested on the SMAW process and 17 welders test coupons were rejected by Moody International; 31 welders were tested on the FCAW process and 16 coupons were rejected; and 9 welders were tested on the SAW process and 4 test coupons were rejected.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
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Reviewed By:	McClary,David	QA Reviewer
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